	er ID 87894 , 2012 2:36:27 PM		*878	94*							Page 1
Revision ID:	D412-761-051 Alternate Armrest		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date: Reference:	7/17/2012 Start Qty: 2.00 7/27/2012 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:		,		(4)	4 t	
Approvals:	Process Plan:F QC:	Date: Q-O	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			-		141		1			
DSI 9520 IIN D412-761	A D										
*100 *100* DC Document Control	CHG002	sefile & type labels per l	0.00 0.00 PPPD412-761-051/ DSI9520 V.A ***	17/07/3.				^	165	121	5)
110 * 11 0*	Pick Kit		0.00							12/5	1205/

0.00

Memo

Packaging

Packaging

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION Rework		Skid-tube	AGAINST DE	PARTMENT,	/PROCESS Water Jet	Engineering
Part No.	<u> </u>				Scrap Use-as-is	1 1	Machining moforming	Small Fab Finishing		d. Eng. Coor.	Quality Other
NCR No.					Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other						. F.					

Landin	g Gear	General			
	Bending	Bend	Grain	Ovalized Pressure/	Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperat	ture/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld	
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing Wrong St	ock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other	
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

FAULT CATEGORY

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	er ID 87894 7, 2012 2:36:27 PM			*878	894*				Page	: 2
	D412-761-051			Accept	*N900	04010)* s	etup Start	*NS1*	
Item Name:	Alternate Armrest	0.00			3			Stop	*NS2*	
Start Date: Required Date: Reference:		Qty: 2.00 Qty: 2.00	*2* *2*		Cust Item II Customer:	D:	<u>.</u>			
Approvals:	Process Plan: QC:		Date:	Tooling: SPC (Y/N):	Da		R	un Start Stop	"INK1"	
Sequence ID/ Work Center II	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp	
*120 *120*	QC4-10	0% Inspect kits	for completeness	0.00 (AS 0.00 (16	7/4/30		NO.			
QC Quality Control		Memo		0.00						_
130				0.00					. 11	
130 Packaging	Packagin	g Memo		0.00					12/30	⁷ 2
Packaging			pack for shipping as per	PPPD412-761-051/ DSI9	9520				•	

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

Quality Control

0.00

MUS 12 (03/30)

NCR:	Yes	/ No				WORK ORDER NON-	·co	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	٠	.				Rework			Skid-tube	Crosstube	Ţ	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				·····		Use-as-is	1	l l	noforming	Finishing	1	re/Packaging	Other
NCR	No.					Work Order Update			Large Fab	Composite		Supplier	
								1		-			
Root						ption of work order update		Initial		tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	C	hief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						•							
Equip/Tooling	Ш												-0
Operator	Ш												
Material													
Setup													
Other	Ш								4				
Process													
Supplier		0						,		- 0			
Training		N.						15. ****	,				
Unapproved	Ш												
		· · · · · · · · · · · · · · · · · · ·				 ,	FAU	LT CATE	GORY				
Land		1			_	General	_	7		r	1		7
	-	Bending				Bend	_	Grain	7	<u> </u>	Ovalized	:	Pressure/Forced
	-	Centre N	ot Concer	ntric to	o/s	BOM/Route	\perp	Hardwa			Over/Under	├	Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged	_	⊣ `	ion Incomplete		Part Incorre	· -	Weld
		Crushed/	Crimped.			Burrs	<u> </u>	-1	ions Incomplete/	Unclear	Part Lost/M	-	Wrong Stock Pulled
	\vdash	Cuffs			_	Contamination		Mainte		(14)	Part Moved		*
		Heat Trea			_	Countersink	\vdash	Mislabe		<u> </u>	Positioned \	_	-
		Inspectio	•	Tube		Cut Too Short	L	Misread	d	L.	Power Loss,	'Surge	Other
1	Ripples in Bend			1	Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Order ID:

87894

Parent Item:

D412-761-051

Parent Item Name:

Alternate Armrest

Start Date: 7/17/2012

Required Date: 7/27/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A new issue DD 10.05.18 verf:EC

	535 DD VERF:EC						AS PER E				•		
Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
N310-6 Castellated Nut	,	Purchased	No	,		110	Each	7.0000	0	2	-1-		A.
*	16.5	4		Location		Loc Qty		Loc Code	,				
				ST344		7			4 .				
200				110	139	7			<u> La</u>		,	$\overline{}$	
Bolt		Purchased	No			110	Each	233.0000	III)	$\gamma_{p,s}^{22}$	S Free)	4
				Location		Loc Qty]	Loc Code					
				ST351		233			<u></u>				
4				117		34			75				
					060	49 50			<i>&</i> €	-			
				121	166	100				<u> </u>			
N6-26 olt		Purchased	No			110	Each	4.0000	T	2		·	\leq
4				Location		Loc Oty	<u>]</u>	Loc Code	!				
				ST342		- 4							1
N0601D10	NAS1149D0363J		NI.	1124	489	4			0				L
N960JD10 Vasher AS/	149 00 6/6/	Purchased	No		-	110	Each	0.0000	, w	22	m	2153	42 re
N960JD616L Vasher	•	Purchased	No			110	Each	0.0000		2	M12	04/854	
3694-041 10UNTING PLATE		Manufactured	No			110	Each	0.0000	0	2	B8-	7891	io St
3695-041 lider <u>Ass</u> embly		Manufactured	No			110	Each	0.0000		2	B87	B98	12/7
4097-041 rmrest Assembly		Manufactured	No			110	Each	0.0000	0	2	<u></u>	704	7

		D	QA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE				
	ige.			- .	

									QA Closed:	Date:					
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
					Rework]	Skid-tube	Crosstube		Water Jet	Engineering				
Part N	lo.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality				
	ı				Use-as-is	Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other				
NCR N	lo.				Work Order Update		Large Fab	Composite							
Root				Descri	ption of work order update	Initial	Ac.	tion	Sign &						
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier	Ш]													
Training															
Unapproved		1							2 w	ing.					
						AULT CATE	GORY		•						
Landi	ng Gear				General	П.		_	1	_],				
	Bending			. <u>.</u>	Bend	Grain			Ovalized		Pressure/Forced				
V	—	Not Conce	ntric to (^{D/S} -	BOM/Route	Hardwa			Over/Under	-	Temperature/Cure				
	Cracks	. (Broken/Damaged		ion Incomplete	Na da an	Part Incorre	-	Weld Wrong Stock Pulled				
	_	I/Crimped	•		Burrs		tions Incomplete/ enance	Unclear	Part Lost/M Part Moved	_	Twitoug stock Pulled				
	Cuffs				Countageink	Mislab		-	Positioned V						
	Heat Tro	eat on Strip in	Tubo	-	Countersink Cut Too Short	Misrea		 	Power Loss/		Other				
19860	Ripples	•	Tube		Drill Holes	Offset	u		Ti ower ross/	Juige	Total				
			Evtrucion	, -	Drawing	Out of Calibration									
			Finish		Sequence										
Wave/Twist in Tube Folio				—	e Dimensions										

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Picklist Print
Tuesday, July 17, 2012 2:36:26 PM

Work Order ID: 8	37894	**					4				
Parent Item:	0412-761-051	*				4		Star	t Date: 7/17/2012	Requi	red Date: 7/27/2012
Parent Item Name:	Alternate Armrest	*	4.					Star	rt Qty: 2.00		ired Qty; 2.00
MS21071L3 ANCHOR NUT		Purchased	No		41.5	110	Each	82.0000	3	6	\$
		1+++4		Location		Loc Qty		Loc Code	ev		
			٠.	ST302		82			· · · · · · · · · · · · · · · · · · ·		
		4.0		114348		50		•			\cap
MS2107513 Nutplate	(4)	Purchased	No			110	Each	87.0000	(B) M/	62 YEE	24
				Location		Loc Qty		Loc Code	v.		
	-			ST303 ———————————————————————————————————		1					
				ST321		86				()	
				121825 122141		36 50			/		16
MS24665-302 Cotter Pin		Purchased	No			110	Each	156.0000	3 5	2	
				Location		Loc Qty		Loc Code			-
À				ST309		156					
NASISISH6L WASHER		Purchased	No	120521		156 110	Each	38.0000	213/7	136	
				Location		Loc Qty		Loc Code		, ,	
				ST277		38					
	•	·×		18918		38			7		

DQA: Date: _	
--------------	--

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed	l: Dat	te:
Work Orde	ır.				DISPOSITION				AGAINST [EPARTMEN	T/PROCESS	
Part N					Rework Scrap		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet od. Eng. Coor. ore/Packaging	Engineering Quality Other
NCR N	lo				Use-as-is Work Order Update			Large Fab	Composite		Supplier	Other
Root				Descri	ption of work order update	Į.	nitial	Ac	ction	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	n QC Inspector
Doc/Data												
Equip/Tooling												
Operator							İ					
Material		1					l					
Setup	_											
Other										l,		u .
Process	_								4			
Supplier	_											
Training												
Unapproved]			<u> </u>	T CATE	CORY		_1		
					General	AUL	CATE	GURT				
Landir	ng Gear Bending				Bend		Grain		ſ	Ovalized		Pressure/Forced
	Centre N	ot Conco	ntric to		BOM/Route	-	Hardwa	are	C		er tolerance	Temperature/Cure
	Cracks	or conce	illile to	^{0/3} -	Broken/Damaged	-	•	ion Incomplete	<u> </u>	Part Incor		Weld
	Crushed/	Crimned			Burrs		4	tions Incomplete/	/Unclear	Part Lost/		Wrong Stock Pulled
	Cuffs	Cimpea.	•		Contamination	\vdash	Mainte	-	, onereu,	Part Move	-	
	Heat Trea	at		-	Countersink	\vdash	Mislabe			Positioned		
	Inspectio		Tube		Cut Too Short	—	Misread		ľ	Power Los		Other
Ì	Ripples in				Drill Holes	\vdash	Offset		L			<u> </u>
	Torque V		Extrusio	n	Drawing			Calibration	4-1			
,	Turning S				Finish	\vdash	Out of	Sequence				
Wave/Twist in Tube Folio				-1	e Dimensions		***************************************					

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PARTS LIST

	QTY -051	PART NUMBER	DESCRIPTION
I	Х	D412-761-051	ARMREST KIT, LH
ł	ا	-D3694-0417	MOUNTING PLATE ASSEMBLY
Ī		D3694-1	* KEYWAY
ı	1	D3694-3	* PROTECTIVE PLATE
1	1	D3694-5	* MOUNTING PLATE
1	1	AN526C1032R8	* SCREW
ı	5	AN960JD10	* WASHER
ı	4	MS21042L3	* NUT
ı	2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
ı	1	MS24693-C271	* SCREW (OR MS24693-S271)
	4	MS24693-C273	* SCREW (OR MS24693-S273)
A	1	D3695-041	SLIDER ASSEMBLY
4	1	D3695-1	* SLIDER
Ì	1	D3695-3	* STOPPER
ı	1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
Ì	1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
ı	4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
Ì	4	MS24693-C276	* SCREW (OR MS24693-S276)
	1	D4097-041 /	ARMREST ASSEMBLY
4	1	D3696-041	* ARM ASSEMBLY
ı	1	D3696-1	** ARM
ı	1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
Ì	1	D4098-041	* CUSHION ASSEMBLY
ı	1	D4099-1	* BRACKET
Ì	3	MS21042L3	* NUT
1	5	MS24693-C273	* SCREW
Ì	3	MS24693-C277	* SCREW
	3	NAS1149D0332J	* WASHER
ŀ	511 =	-AN3-6A	BOLT
-	711=	AN6-26	BOLT
ł	* *1	AN310-6	CASTELLATED NUT
1	_ 11	AN960JD10	WASHER
]	1	AN960JD616L	WASHER
4	72	NAS1515H6L	*WASHER
ŀ	1 _	MS24665-302-	-COTTER PIN
1	3 =	MS21071L3 7	ANCHORNUT
4	7 8	MS21075L3 /	NUTPLATE

MS21075L3 / NUTPLATE

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

DATE: ____ CERT. NO.: _ 10.05.10 SH09-4 ISSUE NO .: _

DESIGN	41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	P	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9520	SHEET 2 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.	-#	ALTERNATE ARMREST INSTAL	L NTS
DATE 10.05.10		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	